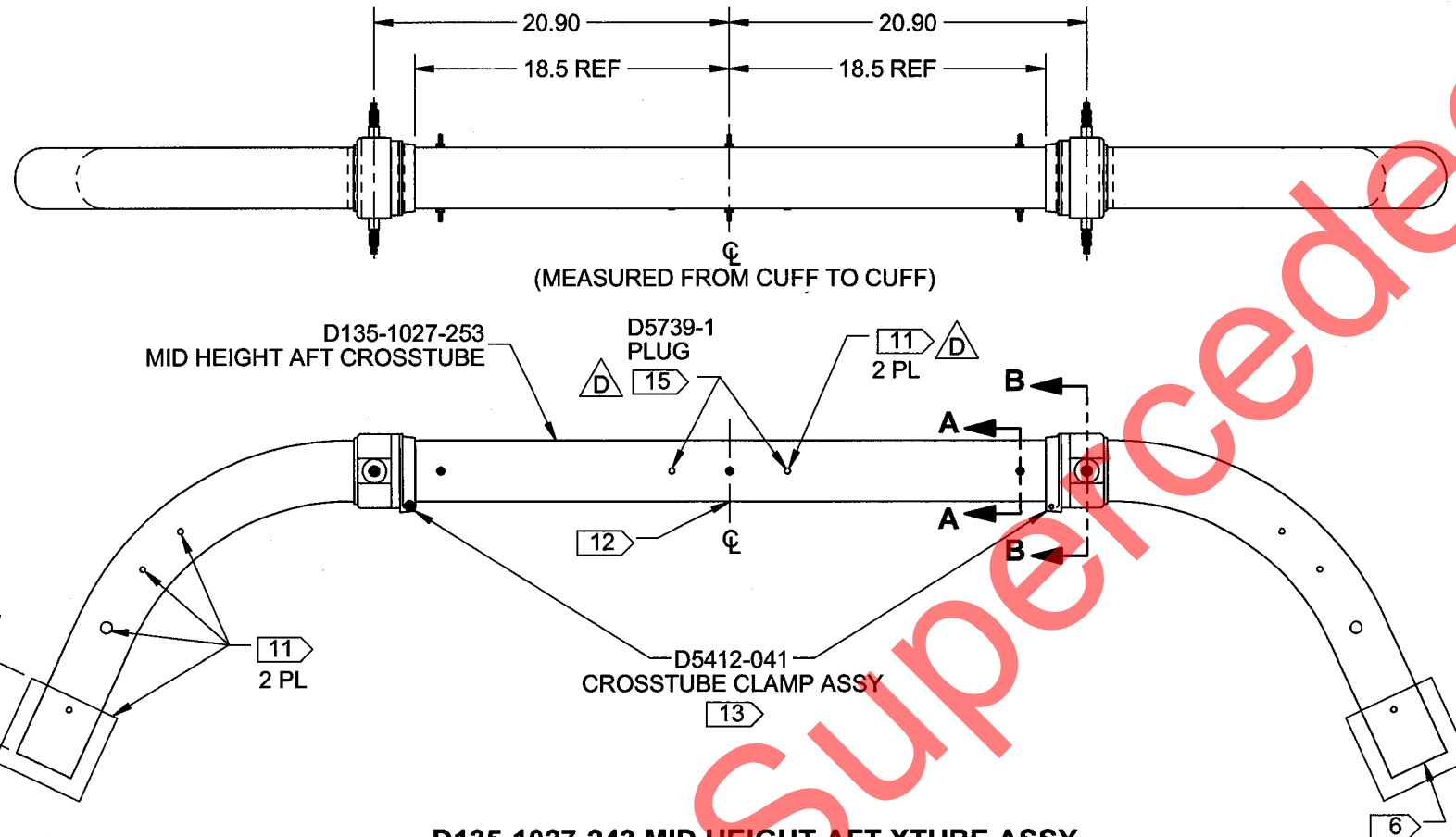


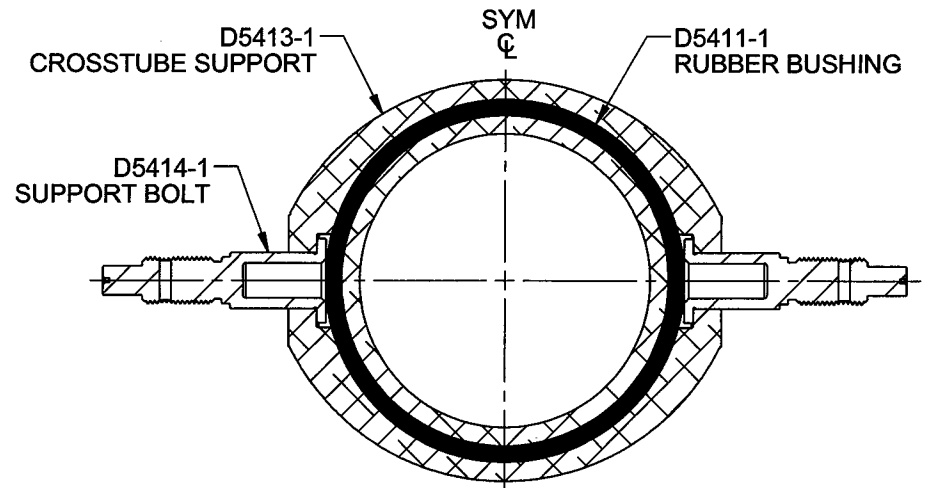
QTY -243	P/N	DESCRIPTION
X	D135-1027-243	MID HEIGHT AFT XTUBE ASSY
1	D135-1027-253	MID HEIGHT AFT CROSSTUBE
2	D5411-1	RUBBER BUSHING
2	D5412-041	CROSSTUBE CLAMP ASSY
2	D5413-1	CROSSTUBE SUPPORT
4	D5414-1	SUPPORT BOLT
3	D5511-1	THREADED ROD
2	D5739-1	PLUG
6	MS35650-304	NUT
6	NAS1149D0363J	WASHER



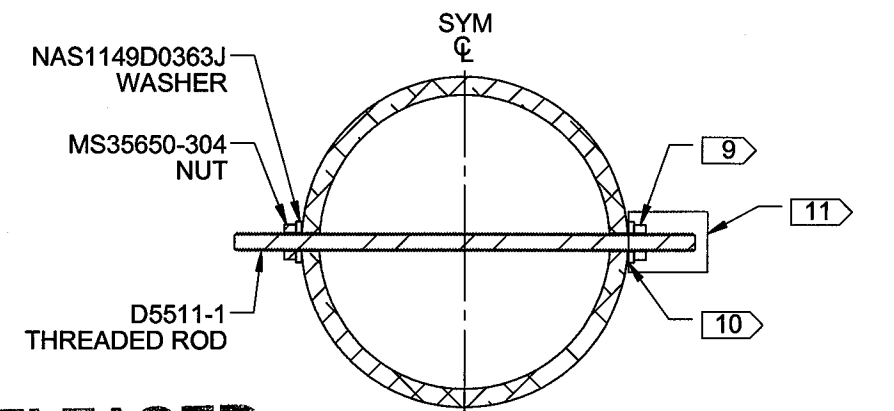
D135-1027-243 MID HEIGHT AFT XTUBE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT BARE TUBE PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PRIOR TO SUPPORT INSTALLATION PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT OUTSIDE PRIOR TO SUPPORT INSTALLATION PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N "D135-1027-243" AND B/N ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 23.87 LBS
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
- 9) PRIOR TO PRIME AND PAINT, APPLY 1 DROP OF LOCKTITE 263 TO THE MATING THREADS OF D5511-1 IMMEDIATELY PRIOR TO INSTALLING AND TORQUING THE MS35650-304 NUT TO 5-10 IN-LBS
- 10) PRIOR TO PRIME AND PAINT, FILLET SEAL USING PR1422 B1/2 OR P/S-890 B1/2 SEALANT
- 11) MASK PRIOR TO PRIME AND PAINT
- 12) AFTER FINISHING MARK THE ENTIRE CIRCUMFERENCE OF THE CROSSTUBE CENTERLINE (± 0.1 ") PER QSI 044 6.1
- 13) PRESS D5412-041 CROSSTUBE CLAMP TIGHT AGAINST D5411-1 RUBBER BUSHING THEN TORQUE BOLT TO 50-70 IN-LBS
- 14) IT IS ACCEPTABLE TO USE MILD SOAP AND WATER OR A SMALL AMOUNT OF WATER BASED LUBRICANT TO INSTALL THE SUPPORTS
- 15) WET INSTALL D5739-1 PLUG USING PR1422 B1/2 OR P/S-890 B1/2 SEALANT



SECTION B-B
2 PL
SCALE 5X



SECTION A-A
3 PL
SCALE 5X

RELEASED

2019 OCT 28
ECN 14-841

D	ADDED QTY (2) D5739-1	MW	19.09.11
C	ADDED D5411-1, D5412-041, D5413-1, AND D5414-1 REVISED NOTES, ADDED SECTION B-B	ZF	18.10.04
B	REMOVED D5541-041/-3/-5	ML	17.08.14
A	NEW ISSUE	AJS	17.06.19
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MW		
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	DD	D135-1027-243	SHEET 1 OF 1
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	MID HEIGHT AFT XTUBE ASSY	NTS
DATE	19.09.11	COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED